

Date: Monday, 16/03/2009 2:00:42 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : CABIN FLOOR PROTECTOR
<b>Job Number</b> : 46509	
<b>Estimate Number</b> : 12660	
<b>P.O. Number</b> :	<b>Part Number</b> : D35741
<b>This Issue</b> : 16/03/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3574 REV.A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 45252	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 24/03/2009 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUL 09 03 14</u>	
<b>Comment</b> : Est Rev :A New Issue 07-01-22 EC	

## Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

ASMEEXS125F6002904

GE PLASTICS LEXAN SHEET



**Comment:** Qty.: 33.6000 sf(s)/Unit Total : 134.4000 sf(s)  
 lexan sheet  
 Batch: 109455

ml 09 03 19 (4)

2.0

WATER JET

FLOW WATER JET



**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3574  
 Dwg Rev: A  
 Prog Rev: A

2-Deburr if necessary

ml 09 03 19 (4)

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



ml 09 03 19



(4)

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



09 03 19 (4)

**Comment:** SECOND CHECK

5.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

SAD 09-03-19 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 16/03/2009 2:00:42 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR

Job Number: 46509

Part Number: D35741

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: \_\_\_\_\_

PPN 46502

9/3/25

50

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/25

Job Completion



mf  
09-03-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	46509
Description: Cabin Floor Protector		Part Number:	D3574-1
Inspection Dwg: D3574 Rev: A		Page 1 of 2	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.001	✓		V&N	
7.37	+/-0.030	7.365	✓		V&N	
11.00	+/-0.030	11.00	✓		M.T	
15.25	+/-0.030	15.25	✓		M.T	
25.87	+/-0.030	25.90	✓		M.T	
39.75	+/-0.030	39.75	✓		M.T	
44.75	+/-0.030	44.75	✓		M.T	
53.51	+/-0.030	53.50	✓		M.T	
63.50	+/-0.030	63.50	✓		M.T	
65.25	+/-0.030	65.25	✓		M.T	
10.75	+/-0.030	10.75	✓		M.T	
14.75	+/-0.030	14.75	✓		M.T	
25.50	+/-0.030	25.50	✓		M.T	
25.75	+/-0.030	25.75	✓		M.T	
26.00	+/-0.030	26.00	✓		M.T	
32.87	+/-0.030	32.87	✓		M.T	
38.81	+/-0.030	38.81	✓		M.T	
45.00	+/-0.030	45.00	✓		M.T	
58.38	+/-0.030	58.38	✓		M.T	
61.25	+/-0.030	61.25	✓		M.T	
64.13	+/-0.030	64.13	✓		M.T	
64.63	+/-0.030	64.63	✓		M.T	
7.50	+/-0.030	7.50	✓		M.T	
9.50	+/-0.030	9.50	✓		M.T	
10.38	+/-0.030	10.38	✓		M.T	
10.88	+/-0.030	10.88	✓		M.T	
14.50	+/-0.030	14.50	✓		M.T	
16.56	+/-0.030	16.56	✓		M.T	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> H10509
<b>Description:</b> Cabin Floor Protector		<b>Part Number:</b> D3574-1
<b>Inspection Dwg:</b> D3574	<b>Rev:</b> A	<b>Page 2 of 2</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

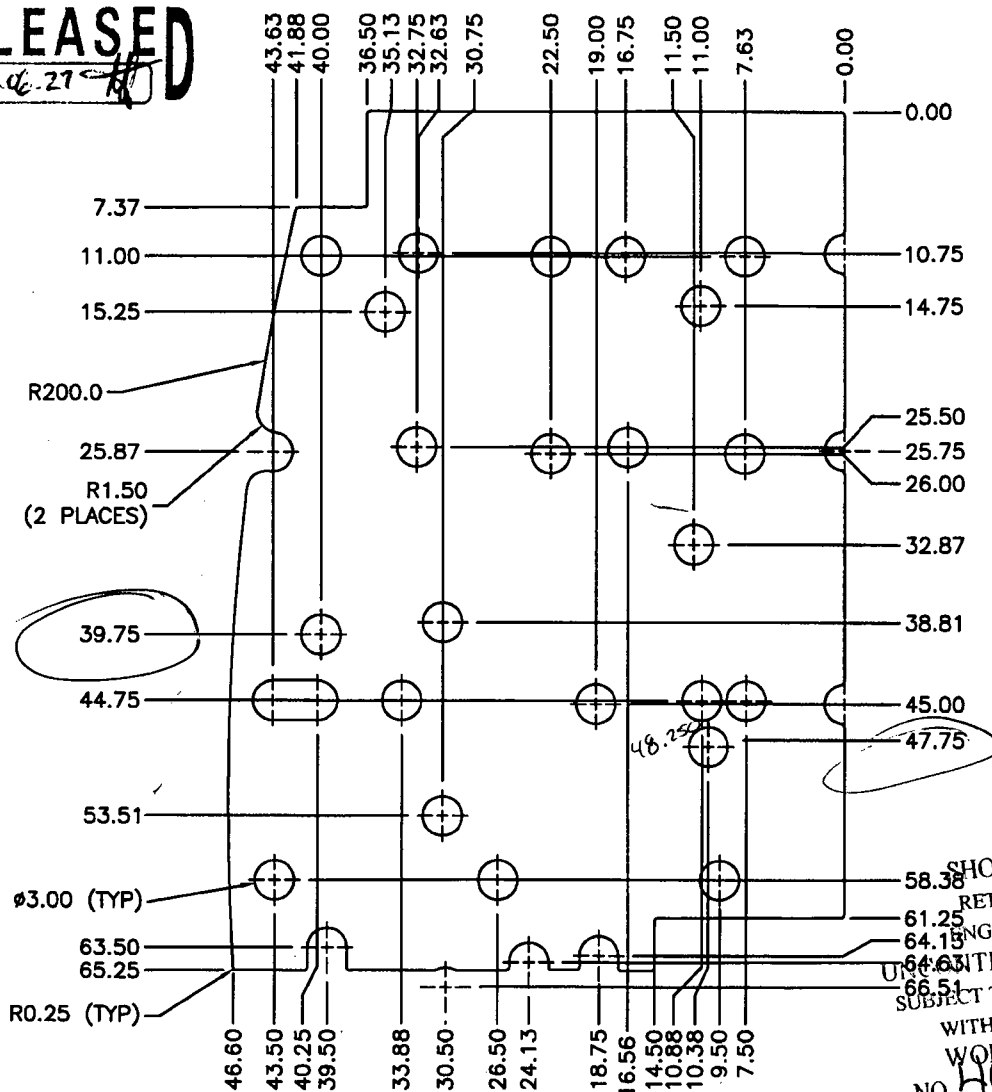
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.75	+/-0.030	18.75	✓		M.T	
24.13	+/-0.030	24.13	✓		M.T	
26.50	+/-0.030	26.50	✓		M.T	
30.50	+/-0.030	30.50	✓		M.T	
33.88	+/-0.030	33.88	✓		M.T	
39.50	+/-0.030	39.50	✓		M.T	
40.25	+/-0.030	40.25	✓		M.T	
43.50	+/-0.030	43.50	✓		M.T	
46.60	+/-0.030	46.60	✓		M.T	
7.63	+/-0.030	7.63	✓		M.T	
11.00	+/-0.030	11.00	✓		M.T	
11.50	+/-0.030	11.50	✓		M.T	
16.75	+/-0.030	16.75	✓		M.T	
19.00	+/-0.030	19.00	✓		M.T	
22.50	+/-0.030	22.50	✓		M.T	
30.75	+/-0.030	30.75	✓		M.T	
32.63	+/-0.030	32.63	✓		M.T	
32.75	+/-0.030	32.75	✓		M.T	
35.13	+/-0.030	35.13	✓		M.T	
36.50	+/-0.030	36.50	✓		M.T	
40.00	+/-0.030	40.00	✓		M.T	
41.88	+/-0.030	41.88	✓		M.T	
43.63	+/-0.030	43.63	✓		M.T	

<b>Measured by:</b> M.M.	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09.03.19	<b>Date:</b> 09.03.19	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	08.07.31	47.75 dimension removed	KJ/DD	

**DART**

DESIGN <b>LE</b>	DRAWN BY <b>CB</b>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>LE</b>	APPROVED <b>H</b>	DRAWING NO. D3574	REV. A SHEET 1 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14
A	07.06.08	NEW ISSUE	

**RELEASED**  
07.06.27**D3574-1 CABIN FLOOR PROTECTOR (SHOWN). D3574-2 (OPPOSITE)****NOTES:**

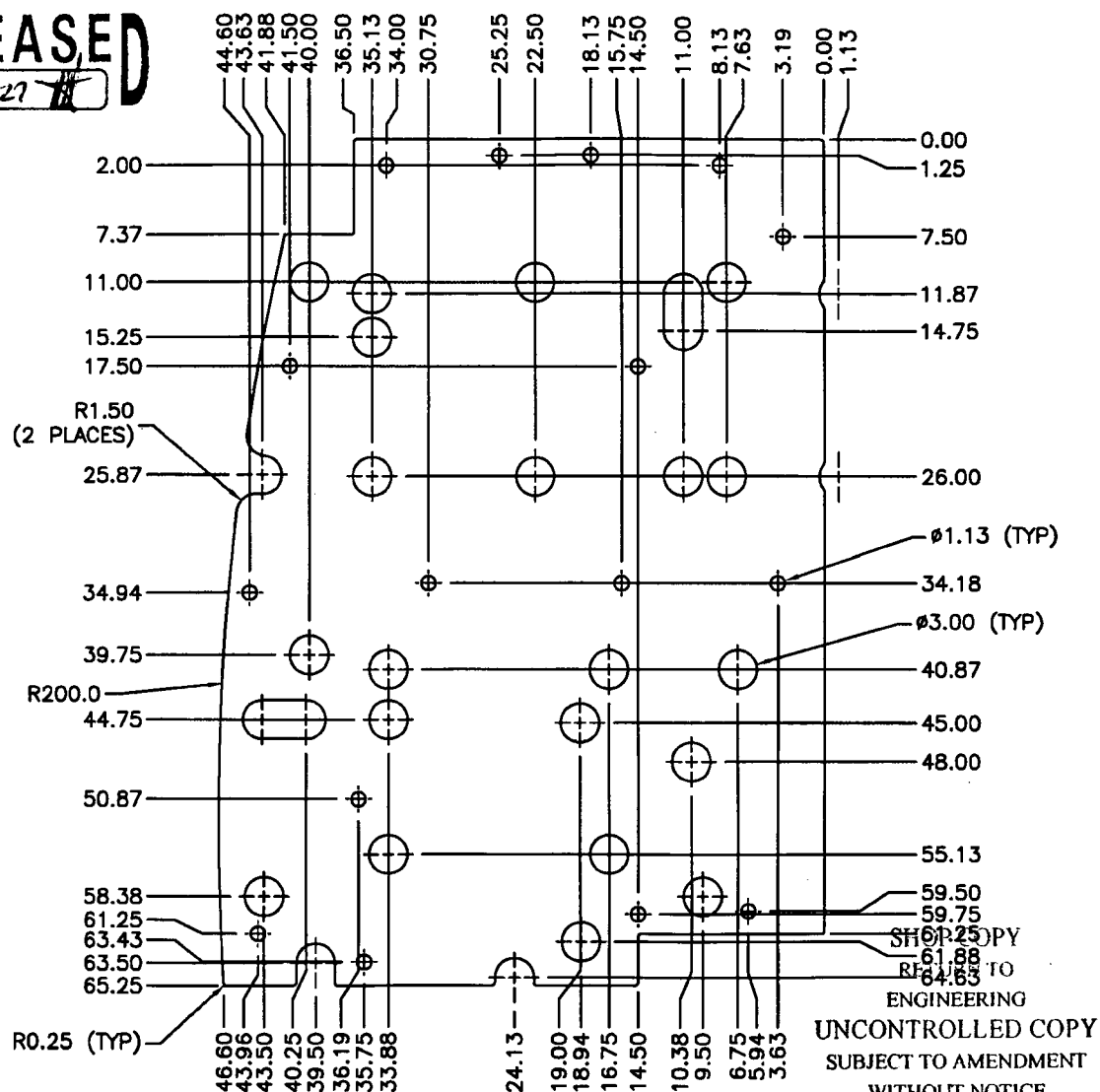
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8961

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CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3574	REV. A SHEET 2 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

**RELEASED**  
07.06.08**D3574-3 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8962

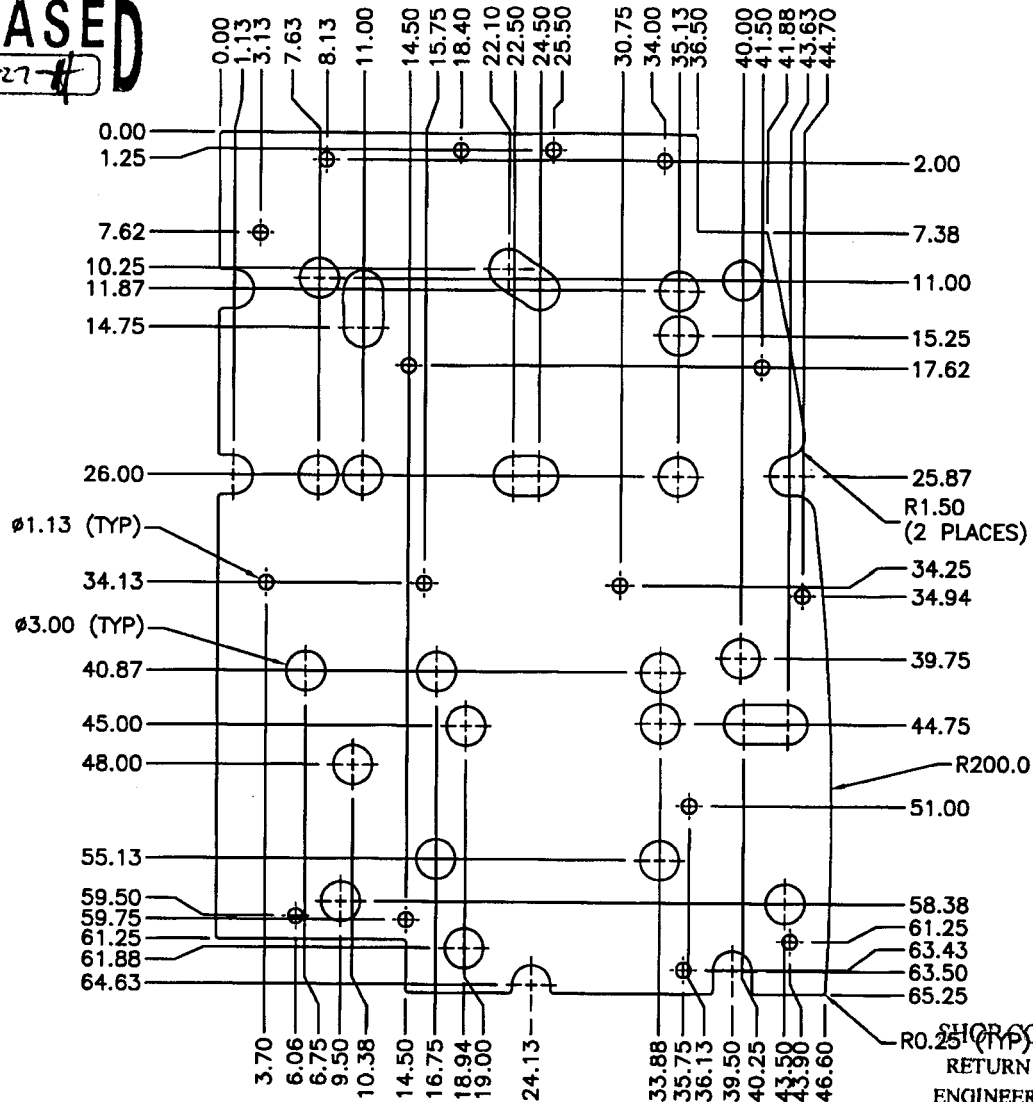
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DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

**RELEASED**  
07.06.27**D3574-4 CABIN FLOOR PROTECTOR****NOTES:**

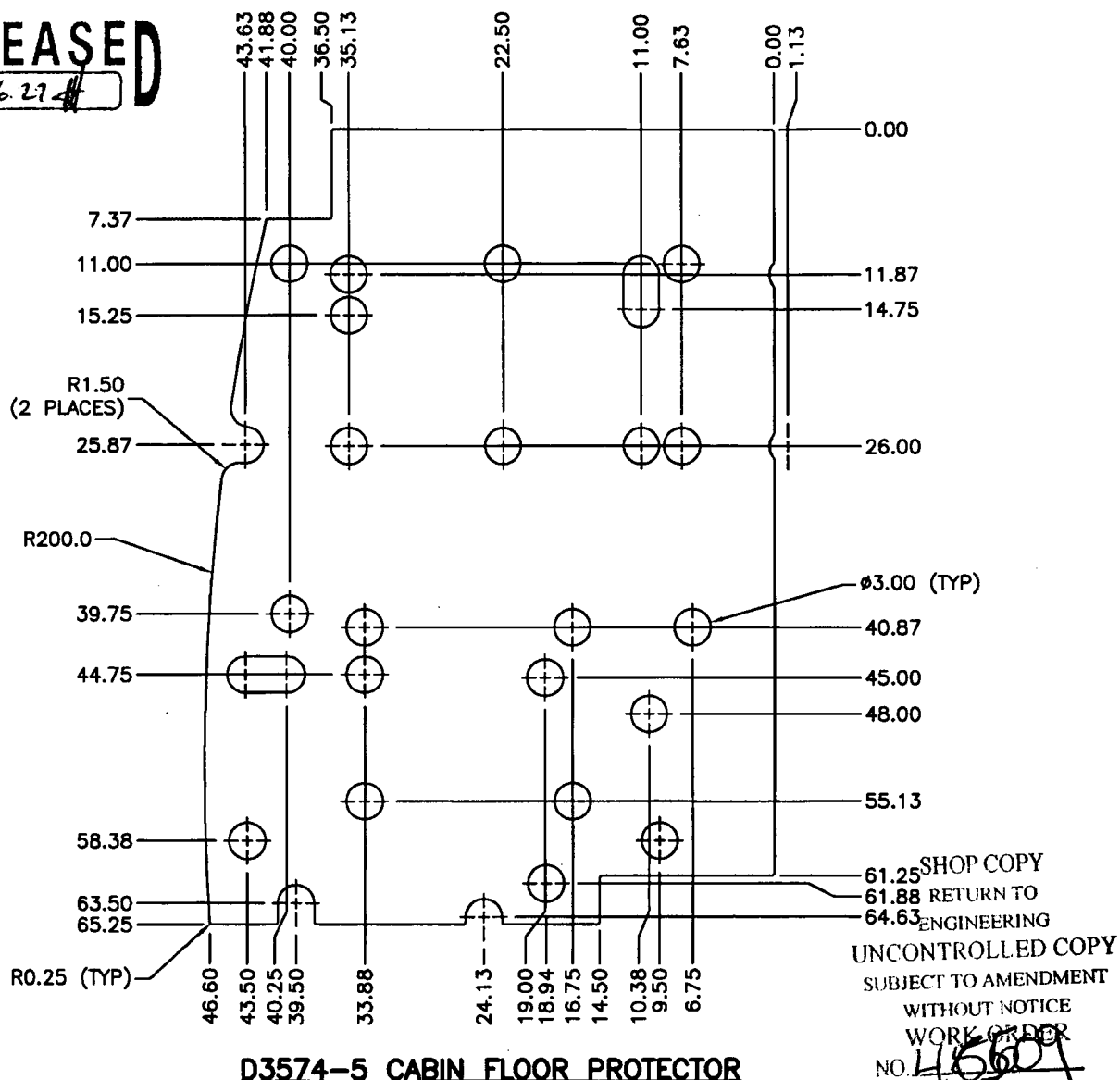
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125" THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8963

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CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3574	REV. A SHEET 4 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

**RELEASED**  
07.06.27**D3574-5 CABIN FLOOR PROTECTOR****NOTES:**

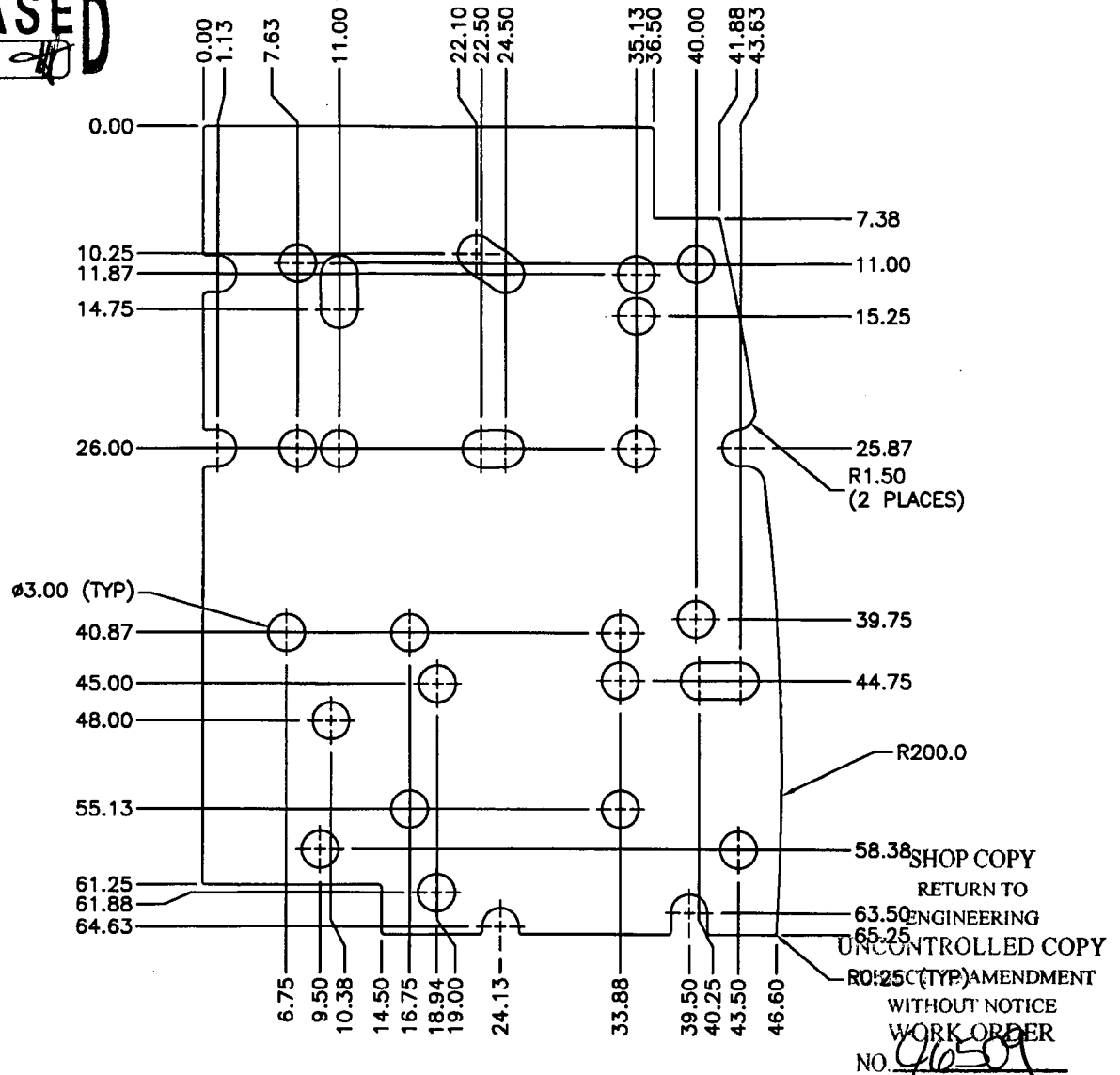
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-5" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8964

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CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3574	REV. A SHEET 5 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

**RELEASED**  
07.06.27**D3574-6 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8965

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